

Date: Thursday, 23/04/2009 3:23:33 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	VALVE ASSEMBLY (1/4")
Job Number	47411		Part Number	D20014
Estimate Number	10962		Drawing Number	D2001 REV C
P.O. Number			Project Number	N/A
This Issue	23/04/2009	S.O. No. :	Drawing Revision	C
Prsht Rev.	NC		Material	:
First Issue	/ /	Type : PURCHASED PARTS	Due Date	10/05/2009
Previous Run	46817		Qty:	6
Written By	:		Um:	Each
Checked & Approved By	<u>JWD 09/04/24</u>			
Comment	Est. A 04.07.06 New Issue KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
	Comment: PURCHASING	
	Issue P/O: <u>8651</u>	<u>C 09/04/27</u>
	P/N: 76-101-32 (1/4 NPT)	
	Possible Supplier: Flo-Control Inc.	
	Material release note is required	(b)
2.0	7610132	VALVE
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 6.0000 Each(s)
	VALVE	
3.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1	
	Recieve & Inspect for Transit Damage	
	Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Remove existing ID numbers and replace with Dart P/N & B/N	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE ASSEMBLY (1/4")

Job Number: 47411

Part Number: D20014

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soilotix (X6)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: St 2

At 09/05/14 (6)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14 (6)

Job Completion



MF
09-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

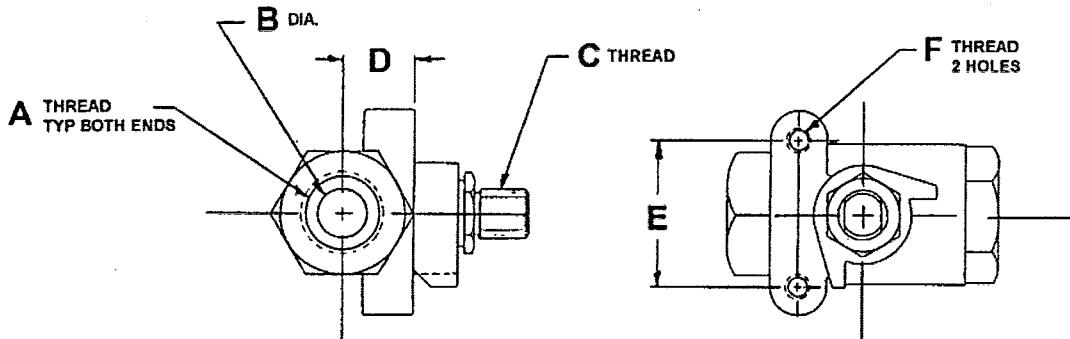
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2001	SHEET 1 OF 1
DATE	TITLE		SCALE
04.07.06	VALVE ASSEMBLY		NTS
-	90.04.02	NEW ISSUE	
A	92.05.12	-043 ADDED	
B	96.04.10	DART P/N CHG,041-6,042-12,ADD -16	
C	04.07.06	ADD D2001-4	

RELEASED
 04.24.07

SPECIFICATION CONTROL DRAWING



Dart P/N	Apollo P/N	A	B	C	D	E	F
D2001-4	76-101-32	1/4 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-6	76-102-01	3/8 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-8	76-103-01	1/2 NPT	0.500	3/8-24 NF	0.60	1.120	10-24 UNC
D2001-12	76-104-01	3/4 NPT	0.680	7/16-20 NF	0.79	1.370	10-24 UNC
D2001-16	76-105-01	1 NPT	0.870	7/16-20	0.99	1.370	10-24 UNC

NOTES:

- 1) POSSIBLE SUPPLIER: FLO-CONTROL INC. OR APOLLO VALVE DIVISION
- 2) DISCARD HANDLE AND ATTACHING NUT, EXCEPT FOR D2001-4
- 3) CHECK DIMENSION SHOWN ON THIS DRAWING
- 4) REFERENCE INFORMATION:

MATERIAL: 316 STAINLESS STEEL
 INVESTMENT CAST COMPONENTS
 MEETS NACE-MR-01-75
 MEETS WW-V-35C TYPE II, COMP SS, STYLE 3
 PRESSURE RATING: 2000 PSI @ 100°F
 150 PSI @ 400°F

- 5) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER NO. 47411

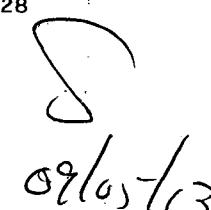
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

Conbraco Industries, Inc.
701 Matthews Mint Hill Rd.
Matthews, NC 28105
(704) 847-9191



Page: 1

Plt(s) STC _____ Pcs _____

Sold to:		Ship To:		** ORIGINAL **			
FLO-CONTROL INC 80 CENTER RD CARTERSVILLE UNITED STATES		DART AEROSPACE LTD 1270 ABERDEEN ST HAWKSBURY UNITED STATES		Pieces: 1	Packed By: LARRYR		
GA 30121		ON K6A1K7		Weight: 7.48	Pack Date: 5/07/09		
				PPD/COL: C	Shipped By: BOBBYP		
					Ship Date: 5/07/09		
					PRO#		
					ASN#		
Customer Number: 01004667		Customer Order: 61861		Order Number: C456027	Date Received: 5/07/09	Salesman: 4	Ship Via/Instructions: FZ01 FDX ACCT# 15179324-0
Line Number	Part Number	Part Description		Quantity Ordered	Quantity Shipped	Unit	Customer Part Number / Comments
1000	<u>7610132A</u>	CONTACT TAG PO# P000008651 AT PHONE; BV, 1/4" NPT, SS, SS TEE HNDL		6	6	EA	
1049	<u>CERTIF01</u>	CERTIFICATE OF COMPLIANCE SHIPPING LOCATION: PAGELAND DISTRIBUTION CENTER 1418 S. PEARL ST.		1	0	EA	Certificate of Compliance N/C PAGELAND, SC 29728
 <u>09/05/13</u>							

DART

Purchase Order

Date Apr 27, 2009	Page 1
Purchase Order Number PO00008651	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED

Vendor Address:

Flo-Control Inc.
80 Center Rd.
Cartersville, GA 30121
Phone (770) 382-0006
Fax (770) 382-0161

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-FL0001	Apr 27, 2009	N30	Fedex	May 04, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
6.0000	7610132	VALVE Comments: AS PER DWG D2001 REV. C B47411 FLO-CONTROL P/N: 76-101-32 (1/4 NPT)	04/05/2009	No	42.740000	Each	256.44

**CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY**

Comments:	Tax Summary:	Less: included tax	0.00
		Subtotal	256.44
		Total tax	0.00
		Total purchase order in	
		USD Dollars	256.44

Entered By: *CL* CLAVOIE

Approved By: *CL*